



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3137-045
Job Sheet 198437

**Part No: D3137-045**

Job Qty: 2 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/29/19

Job Tracking No:

Due Date: 9/3/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 13294

Note: DWG REV F IPP Rev:A 04.02.18 New issue KJ/DS IPP Rev B 08.07.03 ECN1207 EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs	9/3/19		0.00	0.00	Bandsaw - 1		SBL 19/08/19
110	HAAS 4 Axis - B4B	2 pcs	9/3/19		1.00	3.79	HAAS - 1 - B4B		
							HAAS - 2 - B4B		SBL 19/08/19
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	2 pcs	9/3/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBL 19/09/19
							QC 2 - 62		
							QC 2 - 63		



Container No: S206776



Part: D3137 - 045
Job No: 198437
Serial No/Batch: S206776
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5208
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/19/19



Container No: S206776



Part: D3137-045

Job No: 198437

Serial No/Batch: S206776

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/19/19

Plex 7/29/19 1:12 PM Dart.Renwick.Jennifer

7/29/2019 ,

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	2 pcs	9/3/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
140	Small Fab - 2 - B4B	2 pcs	9/3/19	0.00 0.13	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
150	QC 5	2 pcs	9/3/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61

B.F 19-08-20

Smb
19/8/30DAS
40
AUG 3 0 2019
8-59

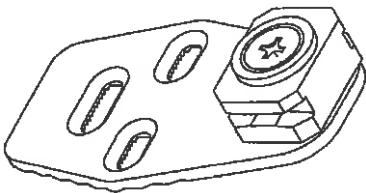
Plex 7/29/19 1:12 PM Dart.Renwick.Jennife

Part Op **100** - Cut blanks: (.500" x 2.000") 4.400" long
 Descriptions: **110** - (HAAS CNC Vertical Machine), 1-Machine D3137-9 as per Folio FA621 and Dwg D3137 Identify as D3137-9 2-
 Debur 3-Scribe batch number
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Assemble D3137-045 as per Dwg D3137
150 - QC5- Inspect part completeness to step on W/O
160 - Identify as per dwg & Stock Location: _____
170 - QC21- Final Inspection - Work Order Release

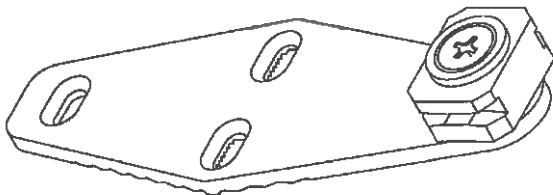
Part / Item	Component Name	Quantity	Operation	Container
D3137-3	Guide	2 pcs (1 ea)	140-Small Fab - 2 - B4B	
D3137-5	Washer	2 pcs (1 ea)	140-Small Fab - 2 - B4B	
MS24094-5101	Screw	2 pcs (1 ea)	140-Small Fab	

Part Specifications

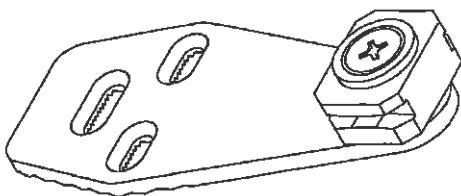
Plex 7/29/19 1:12 PM Dart.Renwick.Jennifer



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



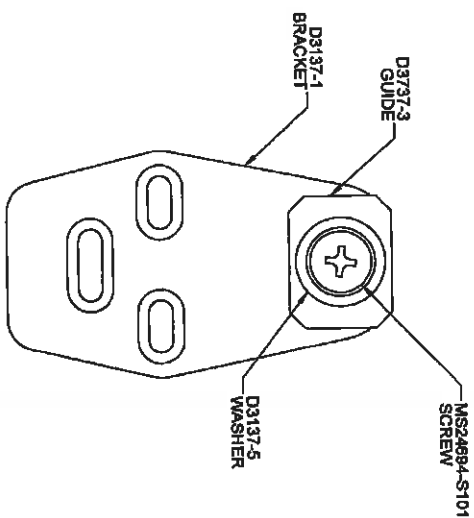
D3137-045 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198437

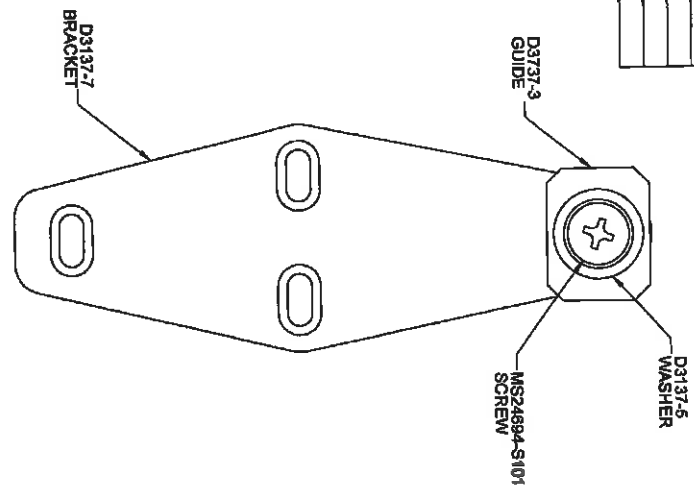
F		ZONE A DIM 2.6 WAS 0.8 ZONE B DIM WAS 0.79 TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	A/S	00-05-30
E	ADD -045		R/F	05-11-23
D	RE-DESIGN D0317-4; CHANGE DIMS		D/S	04-11-03
C	ADD -043		D/S	03-06-15
B	ADD RIDGES; AND MATERIAL PROP		D/S	03-01-16
A	NEW ISSUE		D/S	02-04-17
REV.		DESCRIPTION	BY	DATE
DESIGN	DS			
DRAWN	A/S			
CHECKED	b	DRAINING NO.		
MFG. APPR.	[Signature]	D3137		
APPROVED	[Signature]	TITLE		
DE APRR.	JH	BRACKET ASSEMBLY		
DATE	08.05.30			
PART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA				
REV. F / F				
SHEET 1 OF 5				
SCALE				
NTS				

ASSEMBLY
ELEMENTS
28-06-26

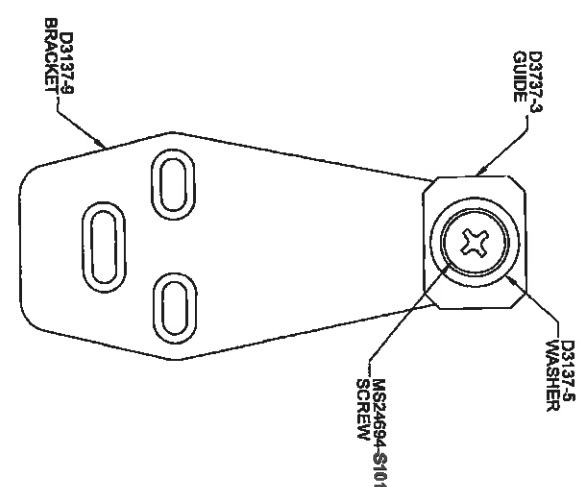
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
			D3137-1	BRACKET
			D3137-3	GUIDE
			D3137-5	WASHER
			D3137-7	BRACKET
			D3137-9	BRACKET
			MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY

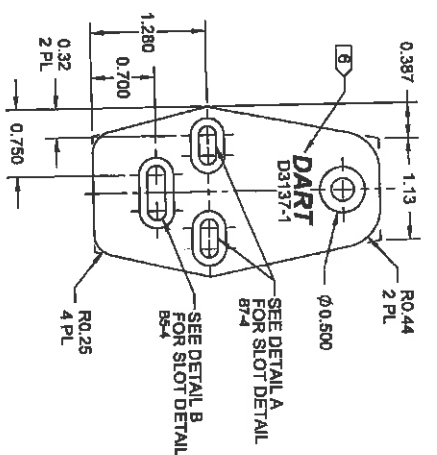
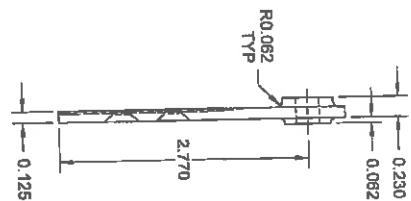
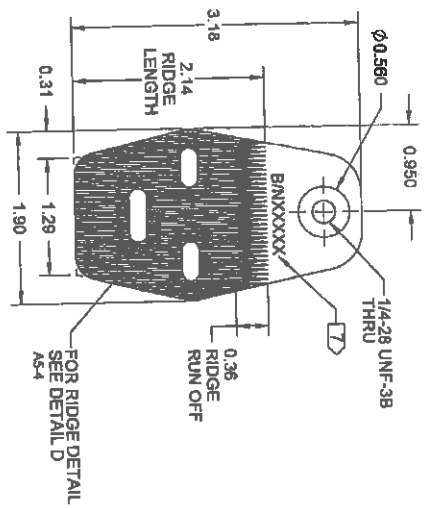


D3137-045 BRACKET ASSEMBLY

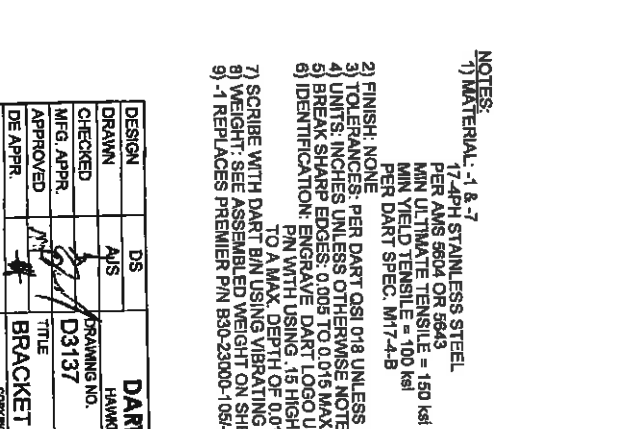
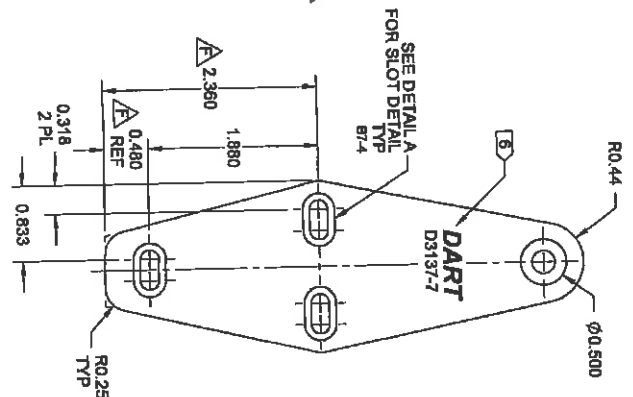
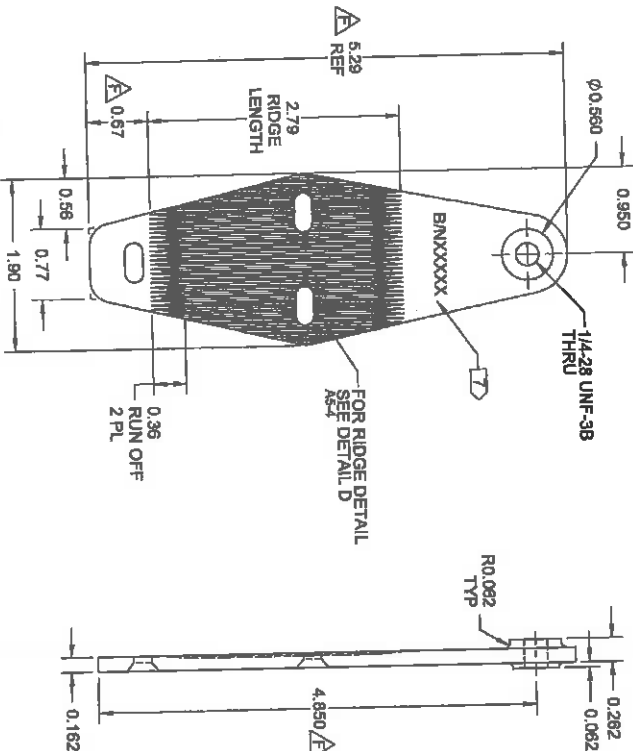
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.18 lbs -041
: 0.32 lbs -043
: 0.27 lbs -045

RELEASED
28 DEC 76/80

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAMKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD	



D3137-1 BRACKET



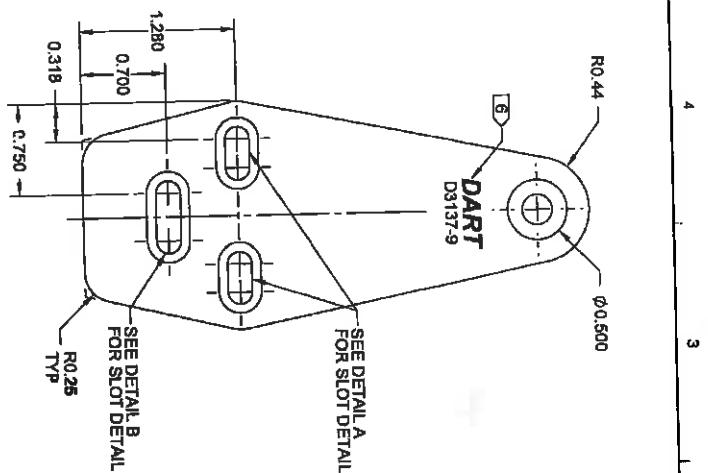
D3137-7 BRACKET

NOTES:

- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & PIN WITH USING .15 HIGH LETTERS
TO A MAX. DEPTH OF 0.010
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET
- 9) -1 REPLACES PREMIER PIN B30-23000-105/

RELEASED

DESIGN	DS	DART AEROSPACE LTD
DRAWN	AJS	HAWKSBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. F
APPROVED		SHEET 3 OF 5
DATE	08.05.30	SCALE
		NTS
		TITLE
		BRACKET ASSEMBLY

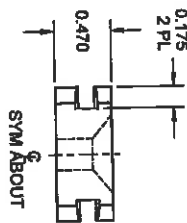
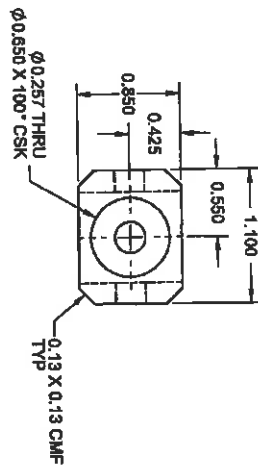


RELEASED
2025-06-26
114

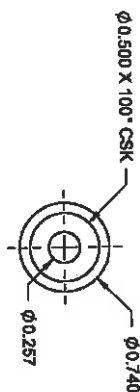
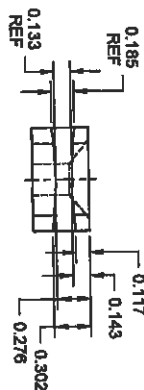
- NOTES:
 1) MATERIAL: 17-4PH STAINLESS STEEL
 PER AMS 5604 OR 5643
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
 PER DART SPEC. M17-4-B
 2) FINISH: NONE
 3) TOLERANCES: PER DART QS. 014 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS &
 PIN WITH USING .16 HIGH LETTERS
 TO A MAX. DEPTH OF 0.010.
 7) SCRIBE WITH DART BN USING VIBRATING STYLUS
 8) WEIGHT: SEE ASSEMBLY WEIGHT ON SHEET 2
 9) REPLACES PREMIER PN B30-23000-105F-105

DESIGN		DS	DART AEROSPACE LTD	
DRAWN		AIS	HAMMERSLEY, ONTARIO, CANADA	
CHECKED			REV. F	
MFG. APPR.			SHEET 4 OF 8	
APPROVED			SCALE	
DC APRIL			NTS	
DATE		08.05.30	BRACKET ASSEMBLY	

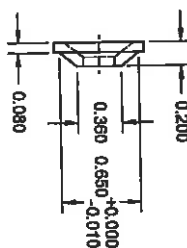
DRAWING NO. D3137
 COPYRIGHT © 2004 BY DART AEROSPACE LTD
 THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.



D3137-3 GUIDE



D3137-5 WASHER



NOTES:
1) MATERIAL: 3 DELRIN II 150E OR ACETRON GP ACETAL BAR
(REF DART SPEC MDELRLN-B)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1 (-6 ONLY)
- 3) TOLERANCES: PER DART OSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
- 9) -5 REPLACES PREMIER P/N B30-2300-209

DESIGN	DS	DART AEROSPACE LTD
DRAWN	LAIS	HAWKESBURY, ONTARIO, CANADA
CHECKED		
ENG. APPR.		
APPROVED		
DE APPR.		
DATE	08.05.30	
TITLE	D3137	BRACKET ASSEMBLY
SCALE		
NTS		

RELEASED
1807014

THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.

DART AEROSPACE LTD		Work Order: 198 437
Description: Bracket		Part Number: D3137-9
Inspection Dwg: D3137	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	.434	✓		Vern	
0.615	+/-0.010	.605	✓			
0.200	+/-0.010	.200	✓			
0.600	+/-0.010	.599	✓			
0.780	+/-0.010	.787	✓			
0.500	+/-0.010	.502	✓			
0.063	+/-0.010	.062	✓			
R0.062	+/-0.010	.062	✓	RG	RG	
0.162	+/-0.010	.159	✓	mic.	mic	
Ø0.560	+0.008/-0.001	.561	✓			
4.21	+/-0.030	4.215	✓	Vern	Vern	
3.770	+/-0.010	3.774	✓	HG	HG	
1.280	+/-0.010	1.286	✓	HG	HG	
0.700	+/-0.010	.703	✓	Vern	Vern	
1.90	+/-0.030	1.900	✓			
100°	+/-0.5°	100°	✓			
2.14	+/-0.030	2.140	✓			
0.262	+/-0.010	.263	✓			
R0.25	+/-0.030	.250	✓		RG	
0.032	+/-0.010	.029	✓		RG	

Measured by: DAS 57	Audited by: Ba	Prototype Approval:	N/A
Date: 9-89 19/08/8	Date: 19-08-20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D3137-045	KJ/JLM	
B	08.12.02	Dwg Rev updated	KJ/DD	
C	09.10.16	Dimension 0.380 & 0.595 removed	KJ	